

Work Order ID **79084 - 2**

79084

Page 1

January-19-12 1:42:16 PM

Item ID: D3560-042

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blanks 16.750" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA694 Rev: AA & Dwg D3560 Rev: 0
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Large Fab

0.00

140

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

Alum. Red #3119712

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Page 3

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N900040100

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6

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6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

12 02 22 80

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

7 0 BE 12/02/12

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

7 SP/ML Feb. 22/2012

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

Ep 12/02/12 (7)

190

Small Fab

0.00

190

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

Ep 12/02/12 (7)

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

8/12/02/12

(7)

W/O:		WORK ORDER CHANGES					
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6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

210

Identify as per dwg & Stock Location: *WA*

0.00

210

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

12-02-22 7

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/2/22
MF
12-02-22

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Picklist Print

January-19-12 1:42:20 PM

Page 1

Work Order ID: 79084

79084

Parent Item: D3560-042

D3560-042

Parent Item Name: Arm Weldment

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

22.0000

1

6

D2808

Bushing

**

Location

Loc Qty

Loc Code

GA

22

32896

2

71879

8

76188

12

M6061T6B0.500X05.00
0

Purchased

No

140

f

59.7480

1.395

8.810526

M6061T6B0 500X05 000

6061-T6 Bar 500 x 5.00

**

Location

Loc Qty

Loc Code

MAT001

35.748

112154

6.935

117933

4.813

119324

24

MAT004

24

120243

24

→ 120421

14.0000 ft

B 78950
7x

GA 12/01/28

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-19-12 1:42:20 PM

Page 2

Work Order ID: 79084

Parent Item: D3560-042

Parent Item Name: Arm Weldment

79084

D3560-042

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 6.00

Required Qty: 6.00

D3592-1

Manufactured No

190

Each

15.0060

1

6

D3592-1

Plate

**

12.02.21

Location

Loc Qty

Loc Code

WA

6

78934

6

WA002

9

47015

2

48517

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

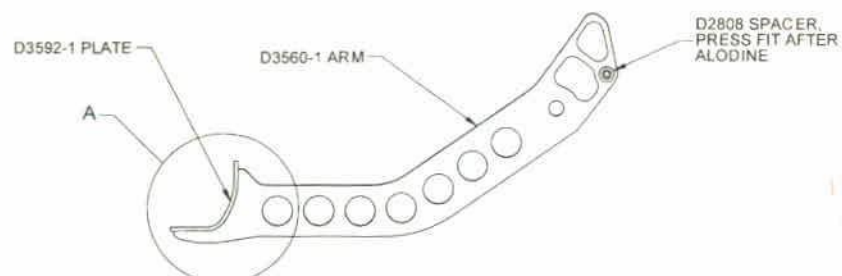
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

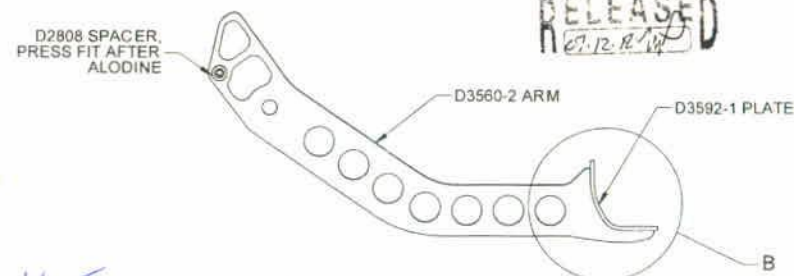
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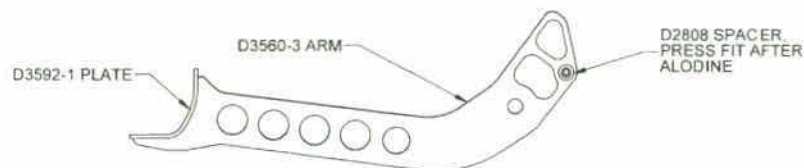
RELEASED
07.12.16



D3560-041 ARM WELDMENT



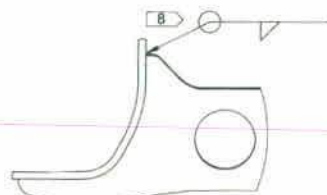
D3560-042 ARM WELDMENT



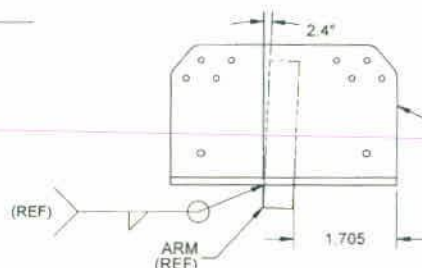
D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1:2**



**DETAIL B
SCALE 1:2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX.
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

DESIGN	ADD D2808 PRESS FIT NOTE. REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.19
CHECKED	REDESIGN AS WELDMENT. ADD POCKETS	CP	07.01.15
MFG. APPR.	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D
TITLE ARM WELDMENT	SHEET 1 OF 5
SCALE 1:4	

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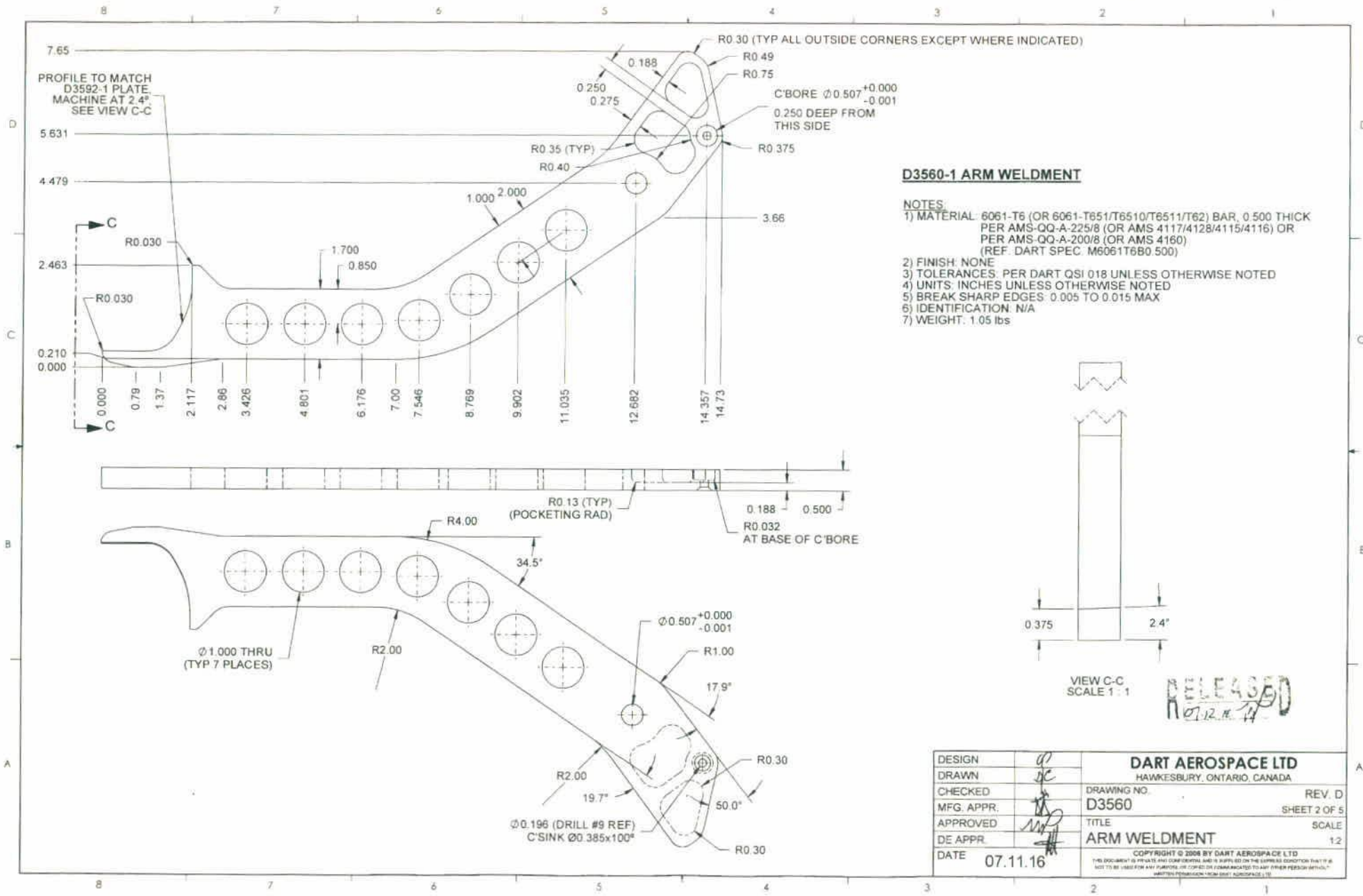
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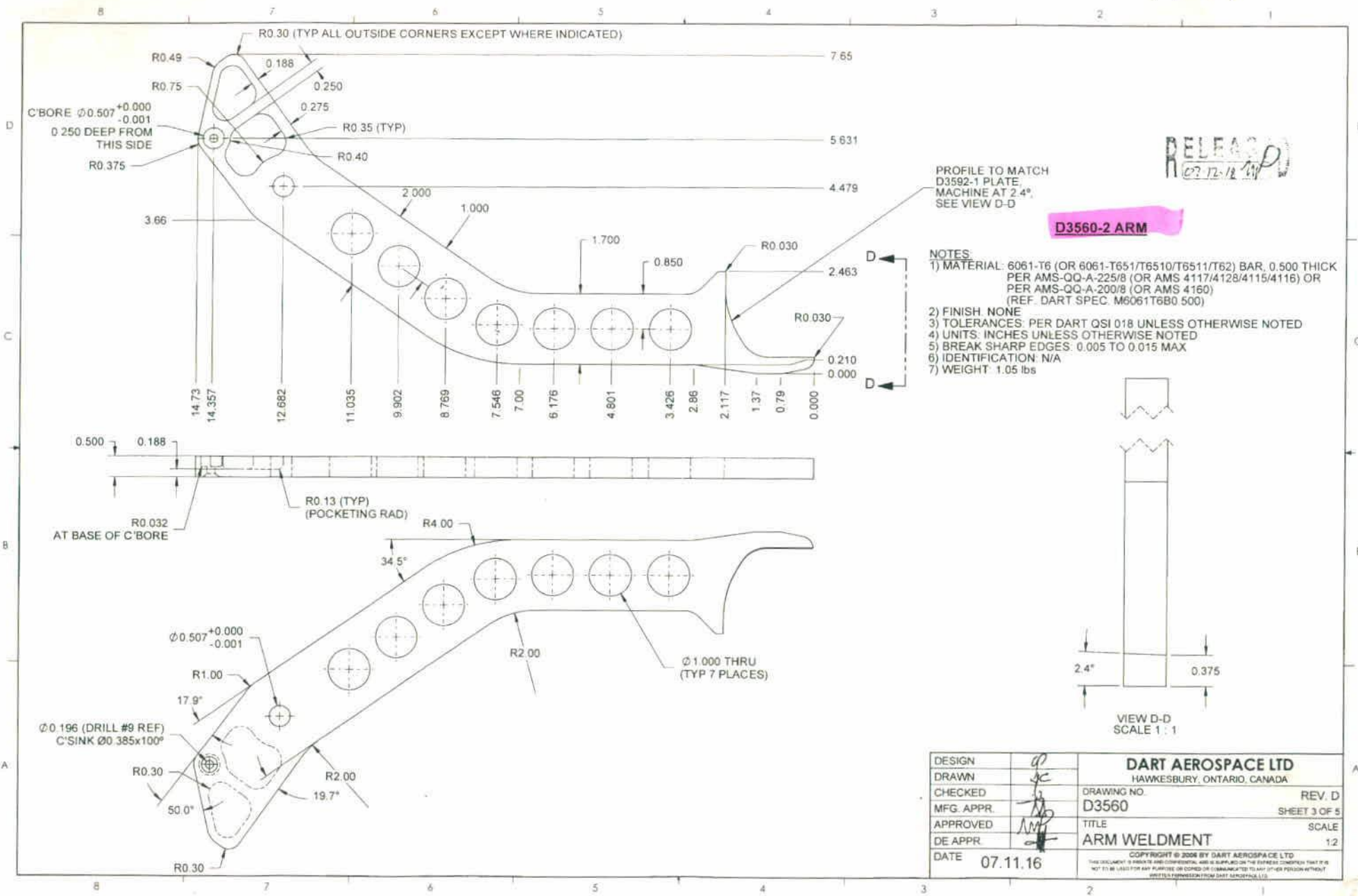
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79084



RELEASED
07-12-14

D3560-2 ARM

DESIGN	g	DART AEROSPACE LTD	
DRAWN	jc	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 3 OF 5
APPROVED	AM	TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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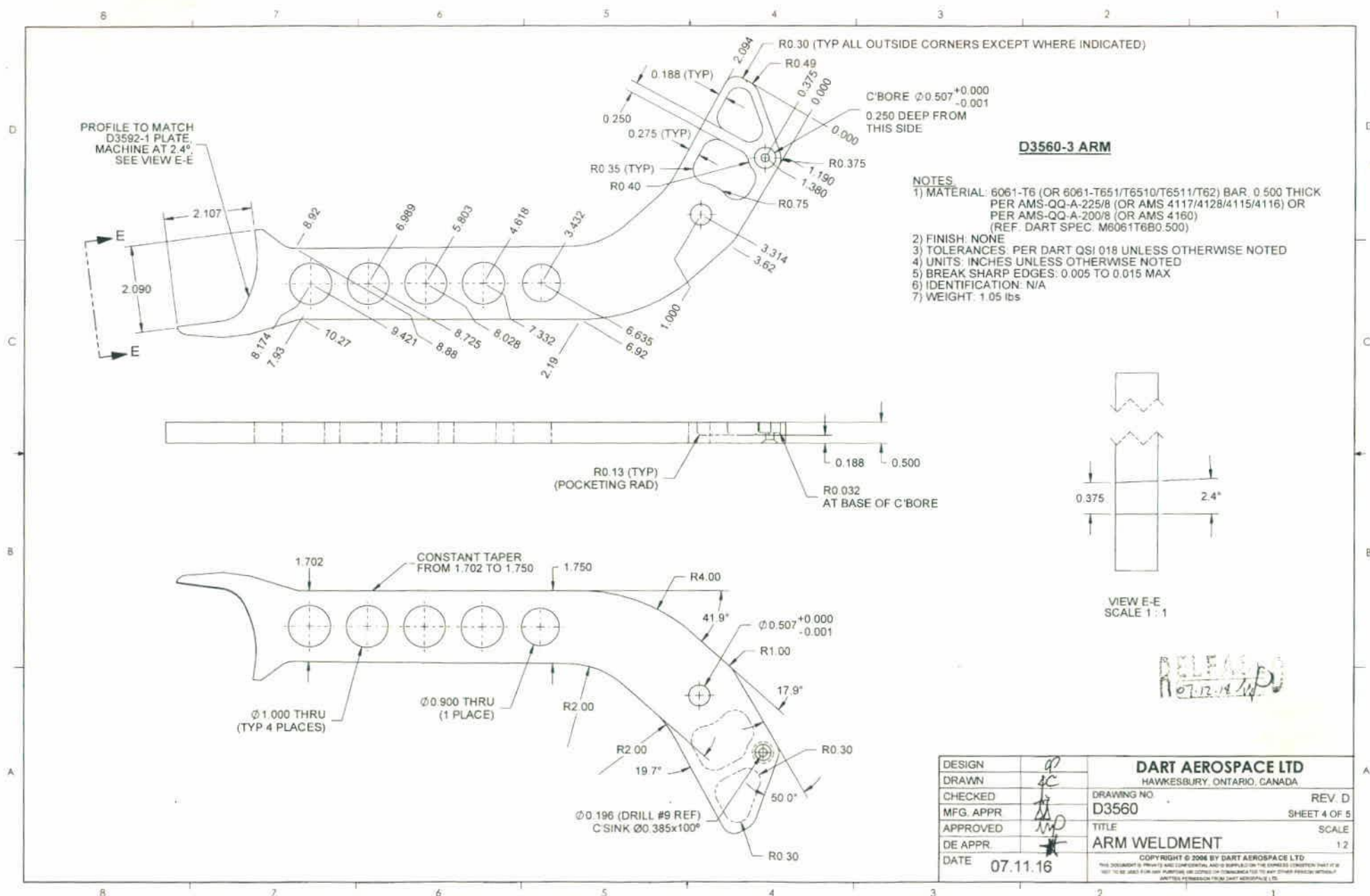
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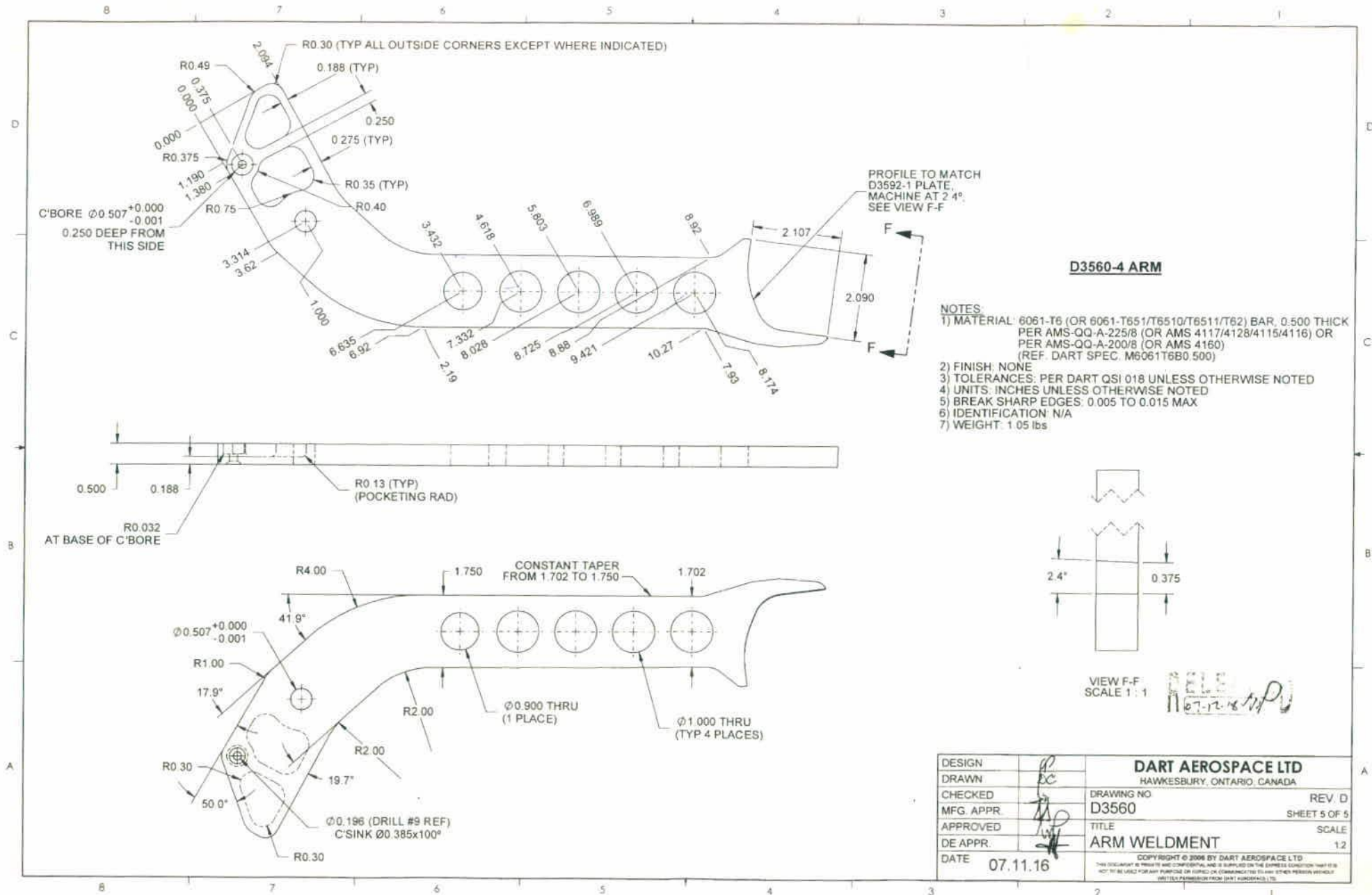
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DART AEROSPACE LTD		Work Order: 79084
Description: Arm		Part Number: D3560-2
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø0.5065	✓		SL02/SL08	
Ø0.196	+0.005/-0.001	Ø0.1965	✓		"	
Ø1.000	+0.010/-0.001	Ø1.004	✓		"	
0.500	+/-0.010	0.500	✓		"	
0.250	+/-0.010	0.250	✓		"	
0.275	+/-0.010	0.275	✓		"	
0.188	+/-0.010	0.189	✓		"	
2.000	+/-0.010	2.001	✓		"	
1.700	+/-0.010	1.701	✓		"	
Ø0.385 x 100°	+/-0.010 x 0.5°	Ø0.380 x 100°	✓		"	
0.250 Deep	+/-0.010	0.249	✓		"	

Measured by: <i>JSR</i>	Audited by: <i>mk</i>	Prototype Approval:	N/A
Date: 12/01/30	Date: 12/01/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-042	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ <i>HG</i>	<i>M</i>